

5/15

<b>DART AEROSPACE LTD</b>	<b>Work Order :</b>	22547
<b>Description:</b> Step Extrusion	<b>Part Number:</b>	D2622-120C
04.04.27 <del>05.02.10</del> CP		
<b>Drawing:</b> D2622 Rev. C1	<b>Qty:</b>	210
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	HA	05.02.24	210
2	PG	Issue P/O: <u>7007634</u> a) Extrude as per Dwg D2622 Rev. C 05.02.10 CP b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 120" long g) Bon L Canada Inc. tool # 897123 Rev. A h) To be packed per DSK 066 i) <b>Pull test to ASTM standard B221 required.</b> j) Material certification is required	U	05.02.24	210
3	RG	Inspect for transit damage <b>Ensure Certification are attached</b>			
4	QC6	Inspect dimensions per Dwg D2622 Check Pull test per Dwg D2622 for compliance page attached. <b>Check hardness with Webster tester</b>			
5	ST	<b>Identify and Stock as D2622-120C</b>			
6	AC	Cost / part <u>0</u>	Sur	05.03.22	
7	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	02.11.12	New Issue	KJ RF	

**RELEASED**  
02.11.18 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

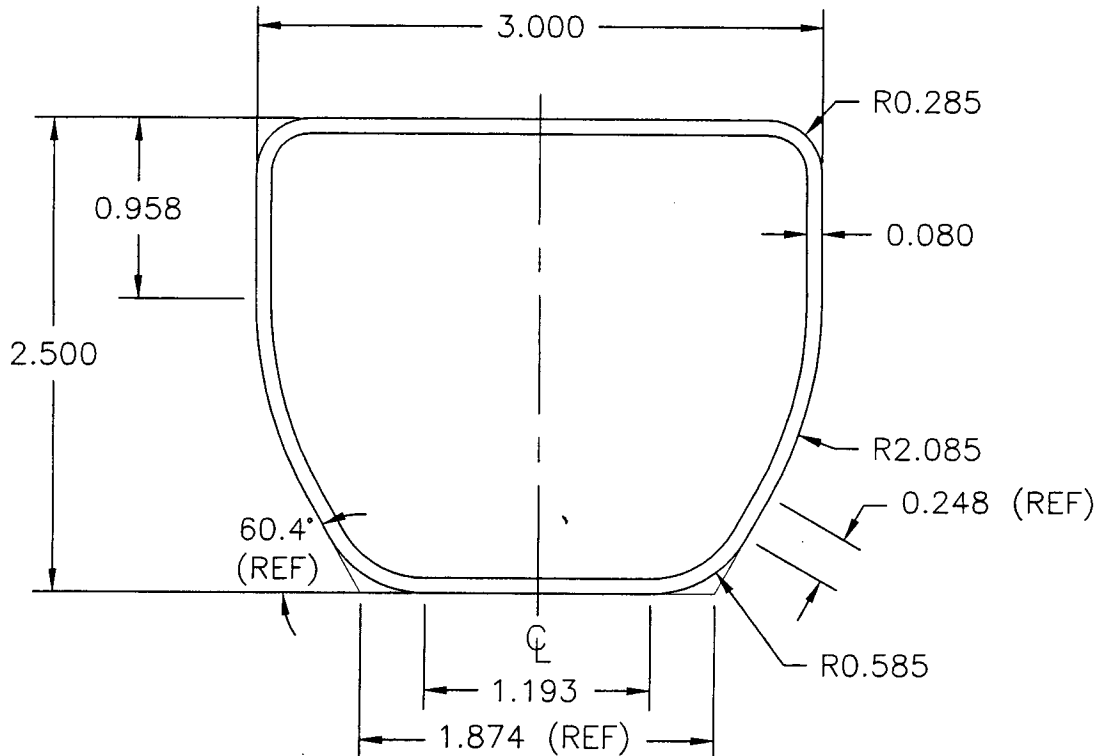
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN KE	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
CI	GP 02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED  
02.09.11 #



#### D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A

- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY  
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UNCONTROLLED COPY  
SUBMIT TO MANAGEMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 22547

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 23, 2005  
02:12 pm

Work Order No	: 0022547	Department Code:	
Project Name	: D2622-120C	Burden Flags	: NNNNNNNN
Project For	: WK515	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2622-120C	Invoice Number	:
Description	: Extrusion	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 210	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 02-23-05	Actual Margin	: 0.000%
Est Finish Date	: 03-30-05		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00